

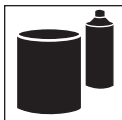


DuPont ChromaSurfacer® 7704S™ 2K Urethane Primer-Filler

Description

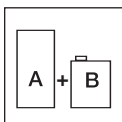
DuPont ChromaSurfacer® 7704S™ is a high build 2K Urethane Primer-Filler with a simple 4:1 mix ratio. The primer has excellent hold out and shares activator with DuPont ChromaSeal® 7710S™/7740S™/7770S™, ChromaClear® 7779S™, and ChromaClear® HC-7776S™.

General Information



Components

DuPont ChromaSurfacer® 7704S™ Primer Filler
 ChromaBase® "4 to 1" 7765S™ Activator-Reducer: (60° F-70° F)
 ChromaBase® "4 to 1" 7775S™ Activator-Reducer: (70° F-80° F)
 ChromaBase® "4 to 1" 7785S™ Activator-Reducer: (80° F-90° F)
 ChromaBase® "4 to 1" 7795S™ Activator-Reducer: (90° F-100° F)



Mix Ratio

Mix 4 (Primer) : 1 (Activator)

Combine the components either by volume or weight and then mix thoroughly. (cumulative pint)

	Volume	Weight (cumulative pint)
DuPont ChromaSurfacer® 7704S™	4	523 grams
ChromaBase® "4 to 1" 77X5S (X = 6,7,8, or 9)	1	617 grams

Viscosity / Pot Life

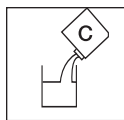
Viscosity : 11 - 12 seconds in a Zahn #3 cup.

Pot Life: 1 hour

Tips for Success

Use mixing stick and a cup with straight sides for accurate measurements.

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Additives

Flex Additive:

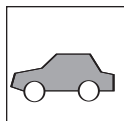
Semi-rigid plastic: Add 1.5 oz Plas-Stick® 2350S™ per RTS pint of primer.

Flexible plastic: Add 2.5 oz Plas-Stick® 2350S™ per RTS pint of primer.

	1.5 oz 2350S™ per RTS pint weight (cum pint)	2.5 oz 2350S™ per RTS pint weight (cum pint)
DuPont ChromaSurfacer® 7704S™	479 grams	453 grams
ChromaBase® "4 to 1" 77X5S X = 6,7,8, or 9)	565 grams	534 grams
Plas-Stick® 2350S™	604 grams	596 grams

Tips for Success:

Keep film builds to a minimum on flexible parts.



Topcoats

ChromaPremier® Basecoat

ChromaPremier Single Stage

ChromaBase® Basecoat

ChromaOne™ Single Stage



Application

Substrates

Sanded OEM substrates

Direct to DuPont™ Variprime® 615S™

Direct to Metal for cut through only

Tips for Success

- *Apply filler using outside-in technique. Allow each coat to flash to a dull even finish before applying next coat.*
- *For best holdout, allow primer to dry overnight.*

DuPont ChromaSurfacer® 7704S™ 2K Urethane Primer-Filler



Surface Preparation

- Clean painted surface thoroughly with mild detergent and water.
- For substrates other than unprimed plastic or fiberglass, wipe surface with DuPont First Klean 3900S™, Prep-Sol® 3919S™, DuPont Kwik Clean 3949S™, or DuPont Surface Klean A-3970S™ /3990S™ Aerosol Surface Cleaners.
- For unprimed plastic and fiberglass, wipe with DuPont Plas-Stick® 2320S™ Plastics Cleaner.
- Sand and featheredge substrate with P180 followed by P240 grit paper.
- Remove sanding sludge with DuPont Final Klean 3901S™, DuPont 3939S™ Lacquer and Enamel Cleaner, DuPont Low VOC Final Klean™ 3909S™, or DuPont™ A-3970S™/3990S™ Aerosol Surface Cleaners.
- All large areas of bare metal must be treated with 2 medium coats of Variprime® 615S™ prior to applying DuPont ChromaSurfacer® 7704S™.

Tips for Success

Avoid the use of excessively coarse grit paper. When working with 36/40 grit scratches, step your way up through P80/P180/P240 DA grit prior to priming to remove coarse scratches and avoid sand scratch swelling in OEM finishes.



Gun Setups

Conventional

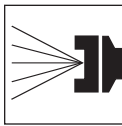
Siphon Feed: 1.8 mm-2.0 mm

Gravity Feed: 1.8 mm-2.0 mm

HVLP

Siphon Feed 1.8 mm-2.0 mm

Gravity Feed: 1.8 mm - 2.0 mm



Air Pressure

Conventional

Siphon Feed: 30 - 40 psi @ the gun cap

Gravity Feed: 20 - 30 psi @ the gun cap

HVLP

Siphon Feed: 7 - 8 psi @ the gun cap

Gravity Feed: 7 - 8 psi @ the gun cap

The listed setups cover the usual range for various application equipment. For information on specific manufacturers' equipment, see the Appendix section titled "Equipment Information."

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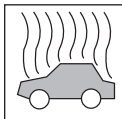
Application

Coats 3 medium wet

DFT 4.5 - 5.5 mils

Tips for Success

Apply medium wet coats; heavy coats have a tendency to “skin dry” and trap solvents. If higher film builds are desired, allow the first coat to dry thoroughly before applying consecutive coats.



Flash/Dry Times

Air Dry

Flash between Coats: 7 - 10 minutes

Wet Sanding: 2 hours

Dry Sanding: 2 hours

Force Dry

Flash before Force Dry: 10 minutes

Cycle Time: 30 minutes at 140° F

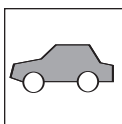
Cool Down: 30 minutes

Infrared Dry

Refer to the Infrared Guide for Set Up Recommendations.

Tips for Success

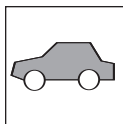
For optimum holdout, air dry overnight, bake or use IR light.



Recoatability/Re-repair

- When topcoating primer, sanding is required if the primer has been allowed to sit for more than 16 hours.
- When recoating with ChromaSurfacer® 7704S™, sanding is required if the primer has been allowed to sit for more than 16 hours.

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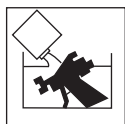


Primer - Sanding

- Sanding: Sand with P240/P320 to remove surface texture and then stepping your way up to P500 or P600 sand paper.
- Remove sanding sludge with DuPont Final Klean 3901S™, DuPont 3939S™ Lacquer and Enamel cleaner, DuPont Low VOC Final Klean™ 3909S™ or DuPont A-3970S™/A-3990S™ Aerosol Surface Cleaners.
- Clean Surface with Sontara PS-39X5S static control wipes before applying sealer or topcoat to ensure a dirt free clean finish.

Tips for Success

- For best holdout, 2 - 3 mils of dry film build should remain on featheredges after sanding.



Cleanup

Clean spray equipment as soon as possible with compliant Gun and Equipment solvent cleaner.

Physical Properties

VOC: 4.2 lbs/gal RTS.

Theoretical Coverage: 683 sq ft / RTS gal at 1 mil.

Weight Solids: 62 % RTS.

Volume Solids: 42.5 % RTS.

Dry Film Thickness: 4.8 mils in 3 coats

Flash Point: See MSDS.

VOC Regulated Areas

These directions refer to the use of products which may be restricted or require special mixing instructions in VOC regulated areas. Follow mixing and usage recommendations in the VOC Compliant Products Chart for your area.

Safety and Handling

WEAR A POSITIVE-PRESSURE, SUPPLIED-AIR RESPIRATOR (NIOSH APPROVED TC-19C), EYE PROTECTION, GLOVES AND PROTECTIVE CLOTHING WHILE MIXING ACTIVATOR WITH PAINT, DURING APPLICATION AND UNTIL ALL VAPORS AND SPRAY MIST ARE EXHAUSTED. Follow respirator manufacturer's directions for respirator use. INDIVIDUALS WITH HISTORY OF LUNG OR BREATHING PROBLEMS OR PRIOR REACTION TO ISOCYANATES SHOULD NOT USE OR BE EXPOSED TO VAPOR OR SPRAY MIST. Do not permit anyone without protection in the painting area.

